

**Work Order ID 68792**

Thursday, April 21, 2011 8:03:05 AM



Page 1

Item ID: D407-649-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Hardpoint (6)

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 120421

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file D407-649 and type labels per QSI 014

CHG001

- 8/15/13

CL 11-4-28

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/28 SP

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/15/13

CL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68792**

Thursday, April 21, 2011 8:03:06 AM

Page 2

Item ID: D407-649-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Hardpoint (6)

Start Date: 4/20/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D407-649-011 Location: 22 □ PPP Rev: C

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

4/20/11

4/15/11

11-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:03:13 AM

Page 1

Work Order ID: 68792

Parent Item: D407-649-011

Parent Item Name: Hardpoint (6)



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 98.12.07 Changed location for step 2 DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
80-007-15-4A ✓ 		Purchased	No			120	Each	0.0000	24	24			
Insert AN4-6A 		Purchased	No			120	Each	1,119.000	24	24			
Bolt													

Location

Loc Qty

Loc Code

ST356

1119

115936

200

116191

119

116400

400

116924

400

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

24

24

Washer

D2713

Manufactured

No

120

Each

14.0000

4

4

Lug

Location

Loc Qty

Loc Code

ST479

14

36699

14

120

Each

5.0000

1

D2755-1

Manufactured

No

Lug

Location

Loc Qty

Loc Code

ST479

5

17551

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:03:13 AM

Page 2

Work Order ID: 68792

Parent Item: D407-649-011

Parent Item Name: Hardpoint (6)

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2755-2



Lug

Manufactured No

120 Each

16.0000



1

Location

Loc Qty

Loc Code

ST479

16

14075

2

17552

4

48383

10

1

D2756



Inner Doubler

Manufactured No

120 Each

45.0000



6

16

Location

Loc Qty

Loc Code

ST022

45

9234

45

D2757



Outer Doubler

Manufactured No

120 Each

0.0000



6

6

M7885/2-4-1



Rivet

Purchased No

120 Each

305.0000



96

96

Location

Loc Qty

Loc Code

ST393

305

110267

305

M7885/3-4-2



Rivet

Purchased No

120 Each

724.0000



126

126

32

32

11/4/08

Thursday, April 21, 2011 8:03:14 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





REFERENCE ONLY

## 6 PARTS LIST

Qty	Part Number	Description
X	D407-649-011	407 HARDPOINT KIT INSTALLATION
4	D2713	BRACKET
1	D2755-1	AFT BRACKET LH
1	D2755-2	AFT BRACKET RH
6	D2756	INNER DOUBLER
6	D2757	OUTER DOUBLER
96	M7885/2	RIVET
126	M7885/3	RIVET
24	AN4-6A	BOLT
24	AN960JD416	WASHER
24	80-007-15-4A	INSERT - DOME HEAD

## 7 HARDPOINT LOAD LIMITS (REFERENCE ONLY)

The maximum limit loads on the Hardpoint Kit are 500 lb vertical load and 280 lb radial horizontal load for each individual hardpoint. The radial horizontal and vertical loads may be applied simultaneously. Any equipment attached to the hardpoints **shall not exceed these loads**.

## 8 CARGO HOOK LIMITATIONS (REFERENCE ONLY)

Loads applied to the Dart Hardpoint Kit Installation will limit the load carrying capacity of the cargo hook according to the following Figure. When the hardpoints are loaded to their maximum capacity, outlined in section 7 of this document, the cargo hook is limited to carrying a maximum load of 1850 lb.

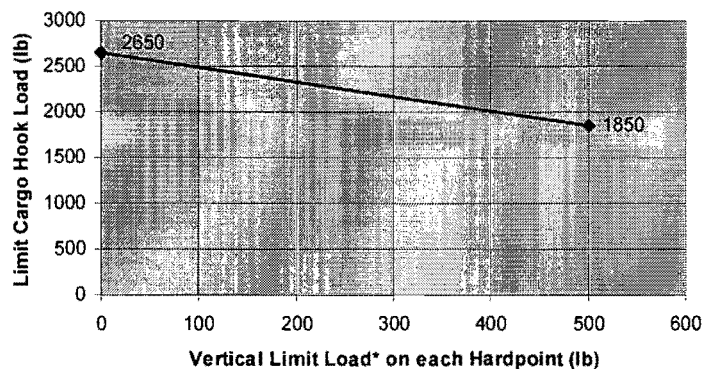


Figure 5 - Cargo Hook Limitations for Hardpoint Loads

\* The Vertical Limit Load on each Hardpoint refers to the maximum allowable vertical limit load for a single hardpoint only. The 500 lb vertical limit load indicated in Figure 5 implies a maximum radial horizontal load of 280 lb, according to section 7 of this document. These limit loads should not be exceeded.





DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9114	REV. A SHEET 1 OF 1
DATE 98.11.03		TITLE 407 HARDPOINT KIT	SCALE NTS
A	98.11.03	NEW ISSUE	

# **DART SERVICE INSTRUCTION**

AMEND DART INSTALLATION INSTRUCTIONS IIN-D407-649 REV. B

STA: SH98-18  
STC: SR00895NY

**REFERENCE ONLY**

DETAILS OF THE CHANGES TO THE PARTS LIST ON PAGE 8 OF  
INSTALLATION INSTRUCTIONS IIN-D407-649 REV. B ARE OUTLINED BELOW:

CHANGE:

96	M7885/2	RIVET
126	M7885/3	RIVET
24	80-007-15-4A	INSERT - DOME HEAD

TO:

96	M7885/2-4-1	RIVET
126	M7885/3-4-2	RIVET
24	80-007-15-4A or SL3149-4A-15 or K100H4A95-15 or FT5215-12A-15 or FIT7623-4A-15	INSERT - DOME HEAD

